

NEW

Dart Aerospace Ltd.

Date: Wednesday, 10/25/2006 11:13:39 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY - UNDER REVIEW  
 Job Number : 29156  
 Estimate Number : 11036  
 P.O. Number : N/A Part Number : D2804041  
 This Issue : 10/25/2006 S.O. No. : N/A Drawing Number : D2804 REV B Rev. C Preliminary Issue  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : UNDER REVIEW OK 06.10.25  
 Previous Run : 29075 Material : N/A  
 Written By : Due Date : 11/1/2006 Qty: 7 Um: Each  
 Checked & Approved By : HA 06 10 25  
 Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28041	STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)  
 STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-1	Bracket	B 29168

2.0	D28051	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)  
 Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-1	Stop	B 29224 (3mx) B 27616 (4mx) MF 06/10/30

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Press D2805-1 into arm as per Dwg D2804

MF 06/10/31

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/31


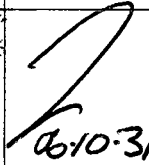
5.0	POWDER COATING	POWDER COATING
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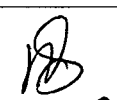
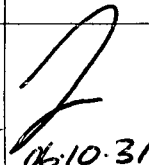
Comment: POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

yl 06/10/31 x7

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/31	12.	Applied LPS Hardcoat on washer + nut + <u>m 17045</u> after assembly	mf.	06/10/31	(7)	 06/10/31	 06/10/31

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/11/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/31	7	1 D 2809 was scrap during press fit	 06/10/31	Scrap - destroy Remove - replace	SB 06/10/31	 06/10/31	 06/10/31	 06/10/31

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY - UNDER REVIEW

Job Number: 29156

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06/10/31

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

MF 06/10/31

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M101884

MF 06/10/31

9.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B-28645

MF 06/10/31

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M102404 (1 MX) M100018 (13 MX)

MF 06/10/31

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	
	M100993		
A/R	LPS-3	Corrosion Spray	M101472

MF 06/10/31

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/11/01

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:13:39 AM  
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## Process Sheet

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Drawing Name: BRACKET ASSEMBLY - UNDER REVIEW

Job Number: 29156

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

MF. 06/10/31.

MF. 06/10/31. (7)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 06/10/31 (7)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57/55

PC 11/21 (7)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 06/11/01 (7)

Job Completion



u do 11/01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

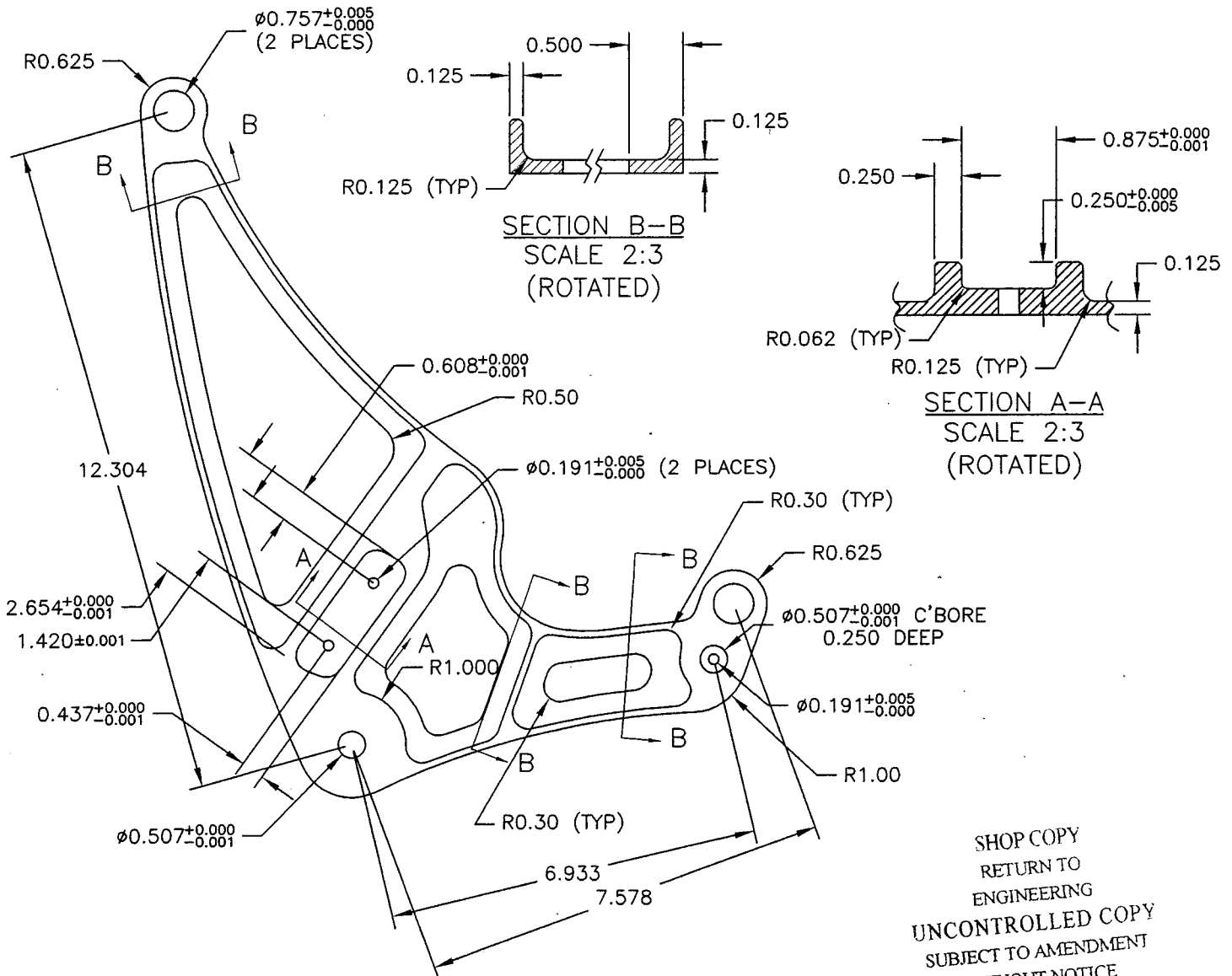
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**PRELIMINARY ISSUE**

DESIGN	CP	DRAWN BY	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2804 REV. C SHEET 1 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE		



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WITHOUT NOTICE  
WORK ORDER  
NO. 29150

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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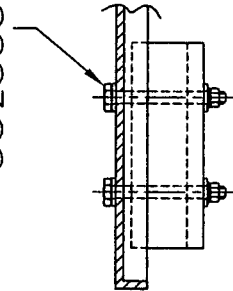
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3

# PRELIMINARY ISSUE

AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21042-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2804-1 FOR D2804-041/-043  
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041  
USE D2805-2 FOR D2804-042  
USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29156

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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